

Work Order ID 64347

Page 1

Friday, December 03, 2010 11:46:50 AM

Item ID: D407-802-018

Accept



Setup Start



Revision ID:

Stop



Item Name: Passenger Door Opener Installation, RH

Start Date: 12/2/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D407-802-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-018 CHG001

Suler/30

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JB 11/05/27

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Suler/30

(72)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D407-802-018

Accept



Setup Start



Revision ID:

Item Name: Passenger Door Opener Installation, RH

Stop



Start Date: 12/2/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-018								
	Location: _____								
	PPP rev: <u>DRAFT</u>								
130		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

12/10/30 (2)

11/15/31 (2)

11-05-30 (2)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 64347

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 12/1/2010






Required Date: 12/15/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
10.12.03 as per dwg rev.A DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-15  Door Prop		Manufactured	No				Each	1.0000		2	✓		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST272A		1							
					63012	1							
D3622-5  Ball Stud		Manufactured	No				Each	0.0000	1	2	✓		
D4108-3  Door Doubler, Right		Manufactured	No				Each	4.0000	1	2	✓		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST129		4							
					62302	4							
D4108-5  Small Right Door Doubler		Manufactured	No				Each	5.0000	1	2	✓		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST129		5							
					62303	5							
D4108-11  Template		Manufactured	No				Each	3.0000	1	2	✓		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		3							
					62304	3							

3563925
B56008

JB Pro →

64302 Rem

64330 JB

JB

62302

JB

62303

JB 11/05/27

62304

Dart Aerospace Ltd

W/O: 64347		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D407-800-018 PAR #: N/A Fault Category: Production Engineering NCR: (P) Yes No DQA: h Date: 11.11.03
 Resolution: Rework Disposition: Rework QA: N/C Closed: Date:

NCR: 11966		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/30	#105	Wrong. Part on parts list D3552-15 should be D3552-17 R.L. Bom + w/o not create correctly LOA.	<u>(Signature)</u> 11.05.30	⇒ Remove D3552-15 and Replace D3552-17 B 6433E correctly update w/o + Bom. ADD copy w/ Bom for Ref.	<u>(Signature)</u> 11/05/30	<u>(Signature)</u> 11/05/30	<u>(Signature)</u> 11.05.30	<u>(Signature)</u> 11/05/30

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 64347

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 2.00

Required Qty: 2.00

D4108-047

Manufactured No

Each

1.0000

1

2



5
77 Sill Doubler Assembly



63010 JB C

Location

Loc Qty

Loc Code

FG

1

62305

1

CR3523-4-02

Purchased No

Each

474.0000

19

38



5
RIVET



62305
116915X5
11729133p

Location

Loc Qty

Loc Code

ST312

300

115768

300

ST313

174

113064

74

116022

100

CR3523-4-4

Purchased No

Each

88.0000

4

8



5
Rivet



8 JB C

Location

Loc Qty

Loc Code

ST314

88

115768

88

MS20426AD4-6

Purchased No

Each

2,193.000

2

4



5
Rivet



115768
4 JB 11/05/27

Location

Loc Qty

Loc Code

ST317

2193

110139

2193

110139

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Shop Packet Print

Page 2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 64347

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 2.00

Required Qty: 2.00

MS21073L5 Purchased No

Each 74.0000

1

2

✓



nut plate

Location

Loc Qty

Loc Code

ST303

74

113660

74

Each

46.0000

2

4

✓

MS27039C1-27

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST293

46

115768

46

Each

6,145.000

2

4

✓

NAS1149C0332R

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST297

6145

115000

125

115698

35

115832

985

116025

2000

116304

3000

Each

96.0000

2

4

✓

NAS1149C1165R

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST297

96

115768

96

115768

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 64347

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0532R

Purchased

No

Each

278.0000

6

12

✓



WASHER



116513 JB

Location

Loc Qty

Loc Code

ST297

278

114348

8

115531

70

116289

200

NAS1149C0563R

Purchased

No

Each

148.0000

6

12

✓



Washer



JB 11/05/27

Location

Loc Qty

Loc Code

ST297

148

115768

148

115768

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

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5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

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Revision: A
Date: 10.10.13